Work Order ID 99891 *99891* Page 1 Friday, April 12, 2013 3:26:47 PM Item ID: D4125-3 Accept *N900040100* Setup Start Revision ID: Item Name: End Start Qty: 6.00 Start Date: 4/12/2013 Cust Item ID: Required Date: 4/19/2013 Req'd Qty: \$.00 Customer: Reference: Date: 13-4-12 Tooling: Run Process Plan: MF Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp Draw Nbr Revision Nbr D4125 100 0.00 *100* 10 PD Bandsaw 13/04/25 0.00 Memo Jeaspa Bandsaw 1-Cut Blank at 6.500" 105 0.00 *105* PD 13/04/26 F.K= 13/04/27 HAAS I Memo HAAS CNC vertical machine #1 Machined as per folio FB079 Deburr

NCR:	Vac	/ No
INCK.	Yes	INO.

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: 13/5/20 Date: 13/5/20 Date: 13/5/8

									QA Closea:	Ca Date	121510
Work Order:	90	9891	П		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.	D.		-3		Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	otion of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	3/04/26	105	1	200	WEUT Throught	(ONS)	Scrop+		13/04/26	8.0	(OAS 16 16
Material Setup Other				Require	TOL ERLOR & TOO! FOL JOB HER TO MODIFIED	Builde	Qty t	700gl		13/05/01	Q72042 13/04/30
Process Supplier Training Unapproved				hooder	vos polin		See .	721.40	#		13/04/30
Electric de la constante de la	-				F	AULT CAT	EGORY (A	11,400			
Landing	Gear Bending Centre No Cracks Crushed/0		ntric to	o/s	General Bend BOM/Route Broken/Damaged Burrs			Unclose E	Ovalized Over/Under Part Incorred Part Lost/Mi	it	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs Heat Trea				Contamination Countersink		tenance	Officieal	Part Moved Positioned V		Wrong Stock Fulled
	Inspection		Tube		Cut Too Short	Misre			Power Loss/S		Other
	Ripples in	Samuel Contract of the Contrac	, 4,5,0		Drill Holes	Offset			1 01101 0007		
	Torque W		xtrusio	n	Drawing		Calibration				
	Turning S				Finish		Sequence				
3	Wave/Tw				Folio	Outsid	de Dimensions				

		The second secon	ter 1
•	NCR: .	Yes	/ No

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NCR: Y	es / No			HIN'S	WORK ORDER NON	-CONFOR	RMANCE / UF	PDATE	QA Closed:	Date	
Work Orde	r: <u>998</u>	91		Allen To	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o. <u>D412</u>	5 -3			Rework Scrap Use-as-is Work Order Update	_	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	- Comment to the comment	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		otion of work order update or Non-conformance	Initial Chief En	100	ction cription	Sign & Date	Verification	QC Inspector
quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	12/04/27	105	ř-	the job progra theres skrap. R.()	id Program manualling required tool for broke, the mod. Since had one issue or 1 point was and uny Tool brick.	002042 13/4/3	Cpl (7.4	F.K- 18/04/27	(608) B/05/01	()AS 16 2-63 A>2072 Bloyl30
Landin	g Gear	•			General	PAULI CAI	EGORT			7 18	
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at on Strip in		0/5	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Instru	vare ction Incomplete ctions Incomplete, tenance beled ad	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque V	Vaves in I	Extrusio	on	Drawing	Out o	f Calibration				

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

99891

Page 2

Friday, April 12, 2013 3:26:47 PM Item ID: D4125-3 Accept *N900040100* Setup Start Revision ID: Stop Item Name: End Start Date: 4/12/2013 Start Qty: 6.00 Cust Item ID: Required Date: 4/19/2013 Reg'd Qty: 6.00 Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp 110 QC2- Inspect parts off machine FAI/FAIB 0.00 13/04/26 *110* 12 B/OH/27 0.00 Memo Quality Control 0A5 08 80 120 QC8- Inspect parts - second check 0.00 *120* QC 0.00 Memo Quality Control 130 Chemical Conversion Coat per QSI005 4.1 0.00 1 \$ Ac 13.05.01 *130* HandFinish 0.00 Memo Hand Finishing

									DQA:	Date	
NCR: Y	es / No	S			WORK ORDER NON-	CONFOR	MANCE / UP	DATE	QA Closed:	Date	
Work Order	r:				DISPOSITION			AGAINST DE		V	
Part No	0				Rework Scrap Use-as-is Work Order Update	- 	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance	Initial Chief Eng		tion ription	Sign & Date	Verification	QC Inspector
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Landin	a Goor				General	AULT CATE	GORY				
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Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

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Ripples in Bend

Turning Sequence Wave/Twist in Tube Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 99891 Friday, April 12, 2013 3:26:47 PM

99891

Page 3

Item ID:

D4125-3

Accept

N900040100

Setup Start

Stop

Revision ID:

Start Date:

Item Name: End

Required Date: 4/19/2013

4/12/2013 Start Qty: 6.00

Operation

Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Sequence ID/ Work Center ID

140

Set Up/ **Run Hours** 0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Stop

Reject Number

Insp. Stamp

140

Quality Control

Description QC3- Inspect Part Finish

Memo

0.00

150

150

Packaging Packaging

Identify as per dwg & Stock Location: WM CO3 0.00

QC21- Final Inspection - Work Order Release

Memo

0.00

160

160

0.00

Memo

0.00

Quality Control

NCR: Y	res / No				WORK ORDER NON-O	100	VFORM	MANCE / UPI	DATE			
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Work Orde	er:				DISPOSITION	,			AGAINST DE	PARTMENT	_	
Part N				_	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	П	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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Landi	Bendin Centre Cracks Crushe Cuffs Heat Tr Inspect Ripples	Not Conce d/Crimped reat ion Strip ir in Bend	ı Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance iled	Jnclear	Ovalized Over/Under of Part Incorrect Part Lost/Mis Part Moved Positioned W Power Loss/S	t ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque	Waves in	Extrusion	1	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

Friday, April 12, 2013 3:26:47 PM

Work Order ID:

99891

Parent Item:

D4125-3

Parent Item Name:

End

Start Date: 4/12/2013

Required Date: 4/19/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC JFS verf:DD

IPP Rev:B 11/12/05 as per rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00' X 8.00		Purchased	No	and A		100	f	4,7370	0.542	3.4231579	PO	13/01	125
				Location		Loc Qty	Lo	c Code					
				MAT005		4,737			The sales	4			
				123	1089	0.085			The second second	Tal Bright		+	
				124	034	3.252 1.4			-	57	张1	3/04/2	28
			_		5386					5,6			
				12	386					57 A	4. 13	14/28	8.

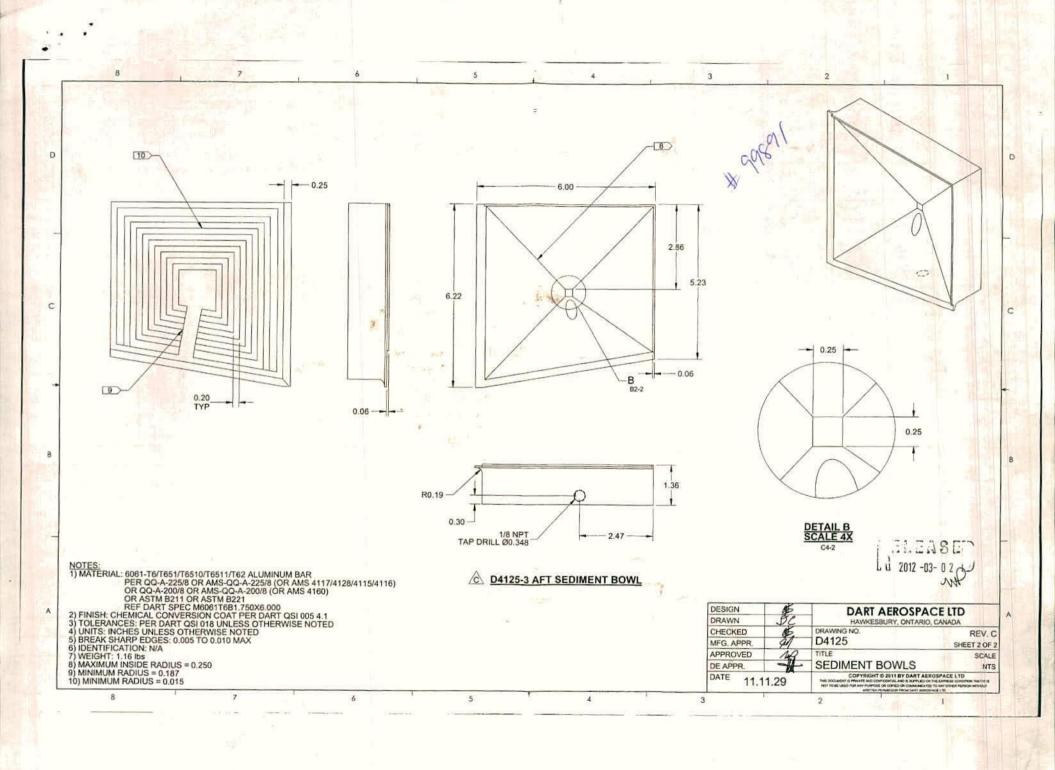
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NCR:	Yes /	No

NCR: Ye	s / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			*
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Part No). 			_	Rework Scrap Use-as-is	-	Skid-tube Machining moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No)				Work Order Update]	Large Fab	Composite		Supplier	
Root				Descr	iption of work order update	Initial	Act	tion	Sign &		-
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occ/Data quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved) =							
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Landing	Bending Centre N Cracks Crushed, Cuffs Heat Tre Inspectio Ripples i Torque N	/Crimped at on Strip in n Bend Waves in I Sequence	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instruc Mainte Mislabe Misrea Offset Out of Out of	tion Incomplete tions Incomplete/lenance eled d Calibration Sequence	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tu	wist in Tul	be		Folio	Outside	e Dimensions				

DQA:

Date:

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											DQA:	Date:	
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Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG		-				Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No	_				Work Order Update			Large Fab	Composite		Supplier	
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Cause		Date	Step	Qty	c	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
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Operator	Ш												
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			ot Concer	ntric to	0/\$	BOM/Route	_	Hardwa		_	Over/Under	A STATE OF	Temperature/Cure
		acks			_	Broken/Damaged		-	on Incomplete	_	Part Incorred	-	Weld
	-		Crimped			Burrs		-	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cu					Contamination		Mainte			Part Moved		
	He	at Trea	at			Countersink		Mislabe	led		Positioned V	-	-
	In	nectio	n Strin in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	478-9
Description: Aft Sediment Bowl	Part Number:	D4125-3
Inspection Dwg: D4125 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	.253	7		FK-04	Vern.
0.20	+/-0.030	.20	7		J,	76
0.06	+/-0.030	٥٥6	7		h	(1)
6.22	+/-0.030	6.215	7		FK-08	Vern.
6.00	+/-0.030	5,999	7		16	1,
2.86	+/-0.030	2.86	1		17x-04	Vern.
5.23	+/-0.030	5.23	7		n	
0.06	+/-0.030	.057	V		h	6
1.36	+/-0.030	1,357	7		N.	(b)
2.47	+/-0.030	2.469	V			1
Ø0.348	+0.006/-0.001	.347	1		ħ	N.
0.30	+/-0.030	, 298			h	A.
R0.19	+/-0.030	- 19	1		R-G	
					io	

Measured by: FK Date: 13/04/27		F.K	Audited by:	DA DAS	Preliminary Approval:	
		Date:		Date:		
Rev	Date	Change			Revised, by	Approved
Δ	12 07 31	New Issue			KI Delt	1///

4.0									DUA.	Date	
NCR: Ye	es / No				WORK ORDER NON-	CONFO	RMANCE / UP	DATE			TO THE TOTAL
pli to	TALL								QA Closed:	Date:	
Work Order: Part No.			DISPOSITION								
		Rework Scrap Use-as-is			The	Skid-tube Crosstube Small Fab Thermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
NCR No	0			-	Work Order Update	_	Large Fab	Composite	1	Supplier	
Root Cause	Date	Step	Qty	Desci	ription of work order update or Non-conformance	Initial Chief E		ction	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	- Date	эсер	Qty	÷ng.	or non-comornance	Cincr E	ng best	an peron	Dute	' crimedian	A STATE OF THE STA
Material Setup Other				1 150	x = 2					No.	
Process Supplier Training Unapproved			1	. 5			a		200	Jes.	
	31.75					FAULT CA	TEGORY		00 8		アペーク
Landin					General		- A		7		1
	Centre Not Concentric to O/S Cracks Crushed/Crimped Burrs Cuffs Cont				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Instr	ction Incomplete ctions Incomplete/Unclear tenance		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1 k	Inspectio Ripples in Torque W	n Strip in Bend			Cut Too Short Drill Holes Drawing	Misr	ead	L	Power Loss/S		Other
	Turning S	equence	1	"	Finish	Out	of Sequence				
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